

Date: Tuesday, 11/14/2006 10:02:41 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : R44 CARGO MIRROR
 Job Number : 29416
 Estimate Number : 10095
 P.O. Number : N/A Part Number : D044715011
 This Issue : 11/14/2006 S.O. No. : N/A Drawing Number : D3243REV A
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : SMALL /MED FAB Drawing Revision : A
 Previous Run : 27068 Material : Manufacture in multiples of 10 Qty: 9 Um: Each
 Due Date : 12/23/2006
 Written By : [Signature]
 Checked & Approved By : [Signature]
 Comment : Est Rev:A 04.02.18 New issue KJ/JLM
 Est Rev:B 06-04-28 Manufactured on Water Jet JLM

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile & type labels per PPPD044-715-011

CHG001

KS 06.11.14

2.0

M6061T6S063

6061-T6 .063 Sheet



Comment: Qty.: 0.5359 sf(s)/Unit Total : 5.3592 sf(s)

Material: 6061-T6 (QQ-A-250/11) 0.063" thick(M6061T6S.063)Identify for D3244-1

Batch: M18556 ml 06.11.29

3.0

WATER JET

FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3243

Dwg Rev: AProg Rev: A

2-Deburr if necessary

ml 06.11.29

4.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

ml 06.11.29 (10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 11/14/2006 10:02:41 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: R44 CARGO MIRROR

Job Number: 29416

Part Number: D044715011

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr

SAD 06:12:03

(10)

7.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Bend as per Dwg D3243

SB 06/12/06

(10)

8.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

Jad 12-07 (10)

9.0

FE032EF

Inserts



Comment: Qty.: 4.0000 Each(s)/Unit Total : 40.0000 Each(s)

Pick:

Qty Part Number

Description Batch

4 FE-032EF

Insert

M100895 (29) M102973 (5)

1 D3243-1(Ref)

Bracket

29416

SAD 07:01:05

(10)

10.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg d3243

Jad 07:01:05 (10)

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

12/7/05 (10)

12.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Chemical Conversion Coat as per QSI 005 4.1

m.e / A

06/12/01

(10)

13.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

1-Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

M.16 / a.m 07/01/03

(10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
06-12-07	9-12	make change as shown		<i>[Signature]</i> 06-12-07			<i>[Signature]</i> 06-12-07

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: ☒ Date: 07/18/18
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 11/14/2006 10:02:42 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: R44 CARGO MIRROR

Job Number: 29416

Part Number: D044715011

Job Number:



Seq. #:

Machine Or Operation:

Description :

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION

11.0



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

11/07/01/05

10

15.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

16.0

D1048

Clamp



Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 D1048

Clamp

B22-91

✓

17.0

D1049

Saddle



Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 D1049

Saddle

B22-73

✓

18.0

D2010104

Mirror Arm 369/500



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 D2010-104

Arm

B29418 SX

B29772

✓

19.0

D2011101

Mirror 6"



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 D2011-101

Mirror

B27163

✓

20.0

ALS41032130

Insert



Comment: Qty.: 4.0000 Each(s)/Unit Total : 40.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

4 ALS4-1032-130Insert

M102478

✓

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: FD Date: 07/10/18
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 11/14/2006 10:02:42 AM
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Process Sheet

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Job Number: 29416

Part Number: D044715011

Job Number:



Seq. #:

Machine Or Operation:

Description :

21.0

AN34A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 40.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

4 AN3-4A

Bolt

M102832 - ✓

22.0

AN526C1032R10

Screw



Comment: Qty.: 4.0000 Each(s)/Unit Total : 40.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

4 AN526C1032R10

Screw

M15072 - ✓

23.0

AN960JD10L

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 40.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

4 AN960JD10L

Washer

M101291 - ✓

PU 7/01/08 (9)

24.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

CL 07/01/18 (9)

25.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D044-715-011

Location:

REDA

PU 7/01/18 (9)

26.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

PU 07/01/18 (9)
W O 7/01/18

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

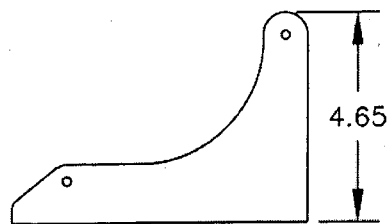
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3243	REV. A SHEET 1 OF 1
DATE 04.01.09	TITLE BRACKET		SCALE 1:2
A	04.01.09	NEW ISSUE	



R0.188 (TYP)



D3243-1 BEND DETAIL/
D3243-041 ASSEMBLY
SCALE 1:4

INSTALL
FE-032-EF INSERTS
(4 PLACES)

2.75 ± 0.030
0.000

11.920

11.420

Ø0.201
(TYP 4
PLACES)

Ø0.290
(TYP 4
PLACES)

1.375

5.273

3.714

0.500

0.000

8.581

8.206

7.706

4.214

R0.25 (TYP)

3.339

R0.38
(TYP)

5.494

GRAIN
DIRECTION

R2.75
(TYP)

R0.50
(TYP)

**D3243-041 BRACKET ASSEMBLY
(D3243-1 BRACKET)**

- 1) MATERIAL: 6061-T6, 0.063 THICK
(QQ-A-250/11, REF DART SPEC
M6061T6S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT
PER DART QSI 005 4.1
POWDER COAT BLACK (4.3.5.7) PER
DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.005 TO
0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018
UNLESS OTHERWISE NOTED

D3243-1
FLAT PATTERN

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 29416

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